

Work Order ID 84732

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84732

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Item ID: D2562-001 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Strut
 Start Date: 22/05/2012 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 05/06/2012 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/05/22 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2562	Rev D								

100
 100 NC BRAKE 0.00
 Brake NC Memo 0.00 10 0 FF 12-08-01
 Brake NC Punch to length as per Dwg D2562 20.73

110
 110 Small Fab 0.00
 Small Fab Memo 0.00 10 0 FF 12-08-01
 Small Fab 1- Bend end as per Dwg D2562 Angle "D"2-Debur

120
 120 QC5- Inspect part completeness to step on W/O 0.00
 QC Memo 0.00 SmB 12 8 01 DAS 16 12 6 8 101 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2562-001 Accept ***N900040100*** Setup Start ***NS1***
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating W121841	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel Memo START TIME: 2:40 FINISH TIME: 4:00 F	0.00 0.00 OVEN TEMPERATURE: 3:10				10X	✓		MF 6/28/01
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				10	X	F	U a 68/01
150 *150* Packaging Packaging	Identify as per dwg & Stock Location <u>252</u> Memo	0.00 0.00				100			sh/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/8/3 JF
 MCL 12/08/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Parent Item: D2562-001

D2562-001

Parent Item Name: Strut

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP F02.04.15Added dwg Rev.B1 NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased											
			No			100	f	132.5474	1.7067	17.96526			

M304TR0 500W 0.35

304 RD Tube .500 x .035W

**

FF 12-08-01

Location

Loc Qty

Loc Code

MAT017 121848

132.5473823

115535

0.913

116720

1.66068

117598

7.6415923

119160

4.79

119644

2.1209

~~120633~~

115.42121

17.96526

~~17.96526~~

W/O:		WORK ORDER CHANGES					
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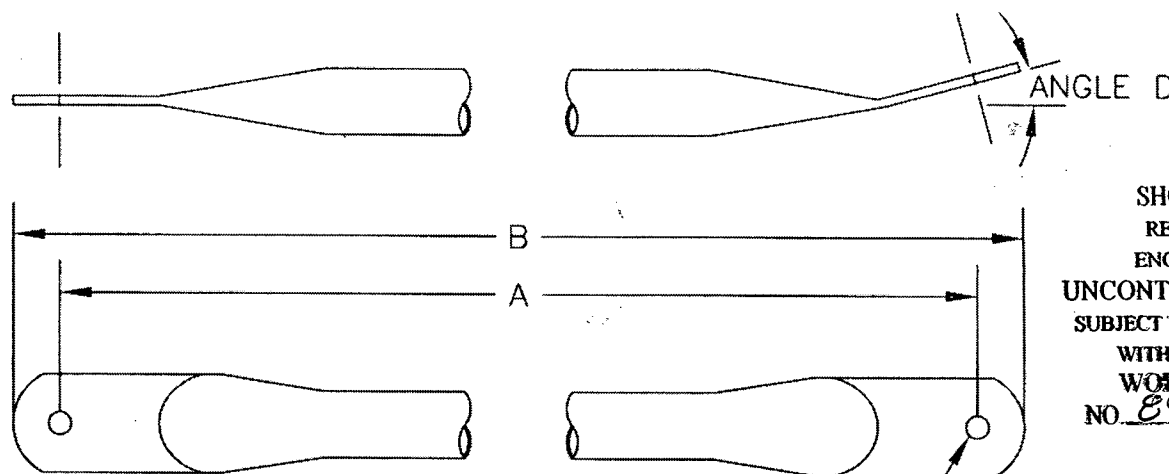
NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84732 MLJ

12/05/22

DESIGN	CP	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	05.05.18	TITLE	D2562	REV. D
			STRUT	SHEET 1 OF 1
A		NEW ISSUE		SCALE
B		UPDATED MATERIAL NOTE (TSR A603)		1:2
C		ADD -005; ADD FINISH		
D		ADD -007/-011/-013; UPDATE -005		



"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2727

PART #	DIM A	DIM B	DIA C	ANG D
D2562-001	19.68	20.48	-	10
D2562-003	20.37	21.17	-	18
D2562-005	29.00	29.80	-	30
D2562-007	19.22	20.02	-	0
D2562-011	25.79	26.59	-	16
D2562-013	26.63	27.43	-	24

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TR0.500W.035)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.05.27

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